

Work Order ID 52100

September 16, 2009 10:11:08 AM



Page 1

Item ID: D3954-9

Accept



Setup Start



Revision ID: A

Stop



Item Name: GWT Chain Pin

Start Date: 09/16/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 09/25/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-09-16 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA & DWG
FOLIO REV: NA
DWG REV: A

5/1 09/07/28

2-DEBURR AS REQUIRED

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

5/1 09/07/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

ml 09/09/28

4 0

Quality Control

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

9/9/28 sp 40

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/09/29

MF 09-09-29

Quality Control

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Picklist Print

September 16, 2009 11:16:47 AM

Page 1

Work Order ID: 52100

Parent Item: D3954-9RevA

Parent Item Name: GWT Chain Pin


Comments:

Start Date: 09/16/2009

Required Date: 09/25/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010 R0.375 		Purchased	No			100	f	49.8845	0.6316			

~~304~~ ROUND BAR 0.375

M1010 -> M1020.
See Proj. List

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	49.88447895	
110166	3.32	
110472	6.41	
112058	0.31317895	
112473	39.8413	

M110860 1018 R.375

- 6 fl. 8A 09/25/25

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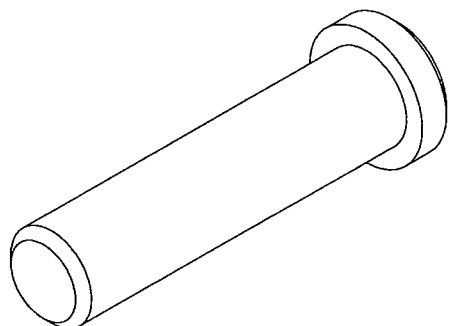
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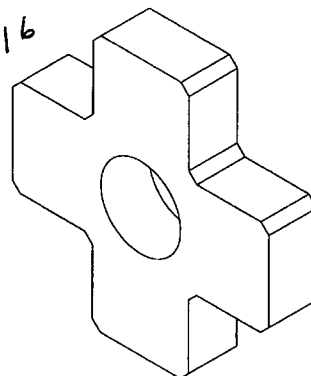
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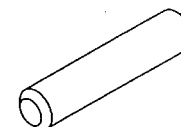


D3954-1 GWT PIN

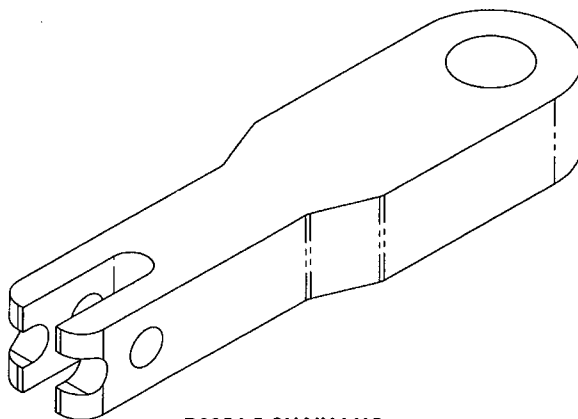
52100
mf
09-09-16



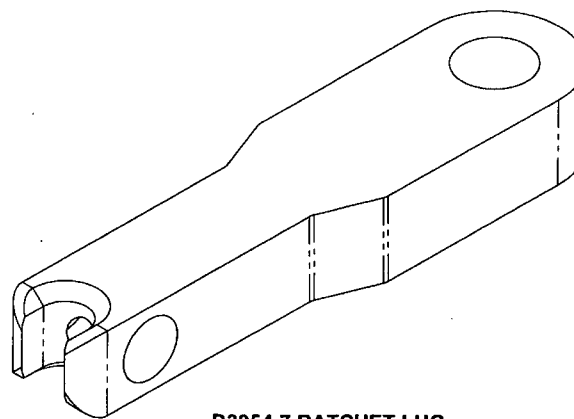
D3954-3 GWT KNOB



D3954-9 GWT CHAIN PIN



D3954-5 CHAIN LUG



D3954-7 RATCHET LUG

RELEASED
09/05/26

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	AJS	09.05.26
DESIGN	AJS/DSTOW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3954	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
DATE	09.05.26	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

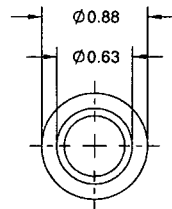
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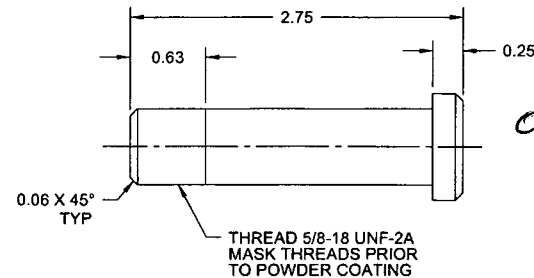
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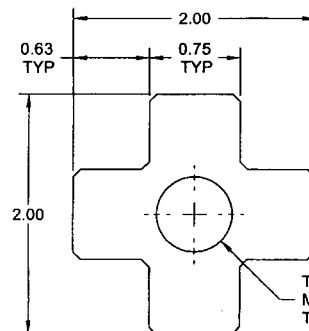
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D3954-1 GWT PIN



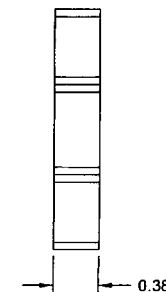
*Okay Mild Steel
ASS 09.09.28*



D3954-3 GWT KNOB

THREAD 5/8-18 UNF-2B THRU
MASK THREADS PRIOR
TO POWDER COATING

0.06 X 45°
TYP



NOTES:

1) MATERIAL -1: AISI 303/304 STAINLESS STEEL ROUND BAR
REF DART SPEC M303/304R

-3: AISI 303/304 STAINLESS STEEL SHEET
PER AMS 5513 OR AMS 5524
REF DART SPEC M303/304S

OR: AISI 303/304 STAINLESS STEEL BAR
REF DART SPEC M303/304B

2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -1: 0.26 lbs

-3: 0.23 lbs

RELEASED
09/08/02

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3954	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	
DATE	09.05.26	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

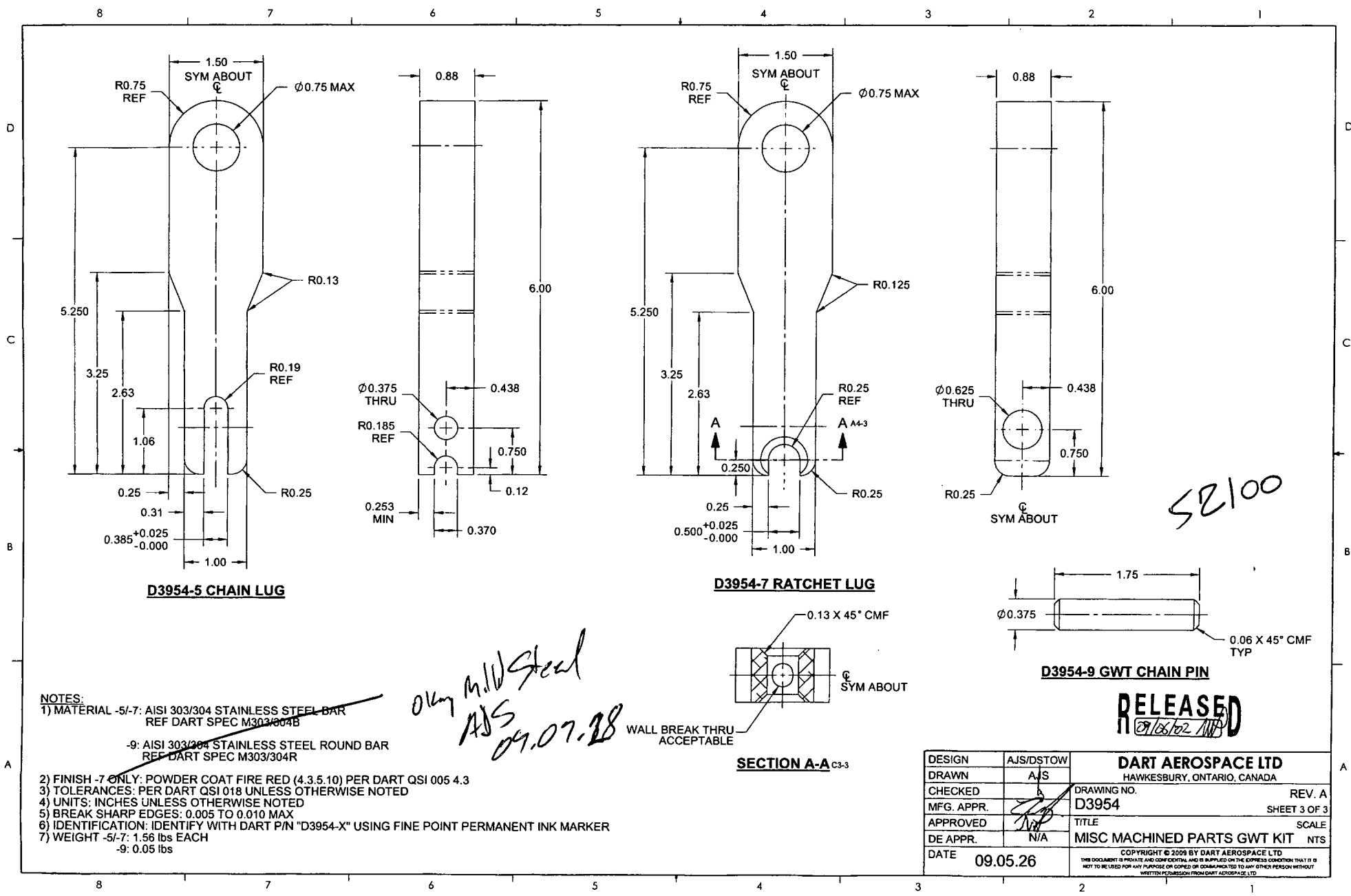
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